Work Order ID 110351 December-17-13 9:24:00 AM	*110351*						Page 1					
Item ID: D3651-3 Revision ID: Item Name: Base		Accept	*N900	<u>040</u>	100) *	Setup Sta	171	S1* S2*			
Start Date: 12/17/13 Start Qty: 1.00 Required Date: 12/17/13 Req'd Qty: 1.00 Reference:	*1* *1*		Cust Item l Customer:	ID:		stra Ua		<u> </u>	• • • • • • • • • • • • • • • • • • • •			
Approvals: Process Plan: ML5	Date: 13-12-18	Tooling:	D:	ate:	_	F	Run Sta	^I <i>V</i> I	R1*			
QC:	Date:		Date:				Sto	, *V	R2*			
Sequence ID/ Operation Work Center ID Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp			
Draw Nbr Revision Nbr												
D3651 Rev B							<u> </u>					
100 ★1∩∩★ Waterjet FLOW WATER JET Memo		0.00					_ 0_		9-89 14-08-1			
FLOW CNC Waterjet 1-Cut as per I Deburr if necessary	Dwg D3651 Dwg Rev: essary	B Prog Rev: B	_ 2-		~.							
110 QC2- Inspect parts off ma	chine FAI/FAIB	0.00							DAS 23			
110 QC Memo Quality Control	•	0.00				\	0		23 989 4-08-17			
120 QC8- Inspect parts - secon	nd check	0.00							DAS			
190 QC Memo		0.00						· ·	9-89 14/08/1			

Quality Control

DQA:		Date:						TAART								
04.61			Data			WORK ORDER NON-	-CC	ONFO	RMANCE / UF		ork Order up	odate only	AEROSPACE			
QA Closed:	_		Date:							V	OIK OIGET G	date only				
Work Orde	r:		•			DISPOSITION				AGAINST D	EPARTMENT	/PROCESS				
	•					Rework			Skid-tube	Crosstube	7	Water Jet	Engineering			
Part N	o.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality			
	•					Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other			
NCR N	lo.	-						Composite		Supplier						
					·		لــــ	L					· · · · · · · · · · · · · · · · · · ·			
Root					Desc	ription of work order update	1	Initial	Acti		Sign &					
Cause	4	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector			
Design	_															
Doc/Data																
Equip/Tooling	_															
Handling/Pre	_						1		ļ							
Material	_															
Operator																
Offset/Setup	_															
Process	_															
Supplier																
Training	\dashv															
Transport	_															
Unapproved					<u> </u>				FECORY		1	<u></u>				
1							FA	ULI CA	TEGORY							
Landin [1				General Bend]Eolio/B	rogram	Г	Outside Dim	ensions [Pressure/Forced			
-	\dashv	Bending Centre No	at Cancan	tric	-	BOM/Route		Grain	Togram	<u> </u>	Over/Under	}	Set-up			
 		Cracks	ot concen	itiit	-	Broken/Damage/Defect		Hardwa	ıro.	 	Part Incorred	<u> </u>	Temperature/Cure			
	\neg	Crimp/Kir	nk/Pinnle	/Mayo	<u> </u>	Burrs	\vdash	4	ion Incomplete/Un	oqualified	Part Lost/Mi	_	Weld			
	_	Cuffs	ik/ Kippie/	vvave	\vdash	Contamination	┢	4	ions Incomplete/U		Part Moved	- T	Wrong Stock Pulled			
	-	Crushing			\vdash	Countersink	┝	1	ned/off center	-	Positioned V	∟ Vrong				
}	$\overline{}$	Heat Trea			-	Cut Too Short	\vdash	Mislabe		<u></u>	Power Loss/		Other			
}	_	Inspection		Tube	-	Drawing	\vdash	Misread		L	J. 55. 2555/		1 3.1.2.			
<u> </u>		Marks/Ch		· ubc	⊢	Drill Holes	\vdash	Off-set								
<u> </u>		Turning S			-	Finish		4	Calibration							
<u> </u>		_	•	e		Fit/Function		4	Sequence		***					
		Wave/Twist in Tube				_		·								

Work Order ID 110351 December-17-13 9:24:00 AM			*110351*						Page 2					
Item ID: Revision ID: Item Name:	D3651-3 Base			Accept	*N900	<u>040</u>	100)* s	Setup Star	17	S1* S2*			
	12/17/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item l Customer:	ID:				1 4				
Approvals: Process Plan:QC:		_ Date:	Tooling: SPC (Y/N):	Date:			R	Run Star Stoj	" " [V]	R1* R2*				
Sequence ID/ Work Center II 130 *120* Brake NC	0	Operation Description NC BRAKE Memo		Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code DAS 30	Accept Qty	Reject Qty	Reject Number	Insp. Stamp (4/(2/0)			
Brake NC			Dwg D3651	0.00			9-89	498 498 (***		n	EC 0 1 2014			
140 QC Quality Control		Memo		0.00				<u>4-89</u> (DAS 38 9-89			
150 *150 *		Identify as per dwg & St	ock Location:	0.00		DA 30 9-8)				<u> </u>			

0.00

Memo

Packaging

Packaging

DQA:		Date:							DART			
					WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:		Date:			<u> </u>				W	ork Order up	odate only	
Work Ordei	r.				DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS	•
WOIR Older	•				Rework			Skid-tube Crosstube]	Water Jet	Engineering
Part No	0.				Scrap			Machining Small Fab	-	Pro	d. Eng. Coor.	Quality
					Use-as-is			noforming Finishing	\vdash	4	re/Packaging	Other
NCR No	0				Suspected Unapproved		Large Fab Composit				Supplier	
Root				Desci	scription of work order update		nitial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design		1										
Doc/Data		1										
Equip/Tooling												
Handling/Pre												
Material	_											
Operator												
Offset/Setup												
Process												
Supplier	_											
Training												
Transport	_											
Unapproved		1										
						FAI	ULT CA	TEGORY				
Landing	g Gear				General		7			1	_	1
	Bending				Bend		1	Program		Outside Dim		Pressure/Forced
	Centre N	ot Conce	ntric	<u> </u>	BOM/Route	<u> </u>	Grain			Over/Under	ļ	Set-up
	Cracks				Broken/Damage/Defect		Hardwa			Part Incorred		Temperature/Cure
L	Crimp/Ki	nk/Ripple	/Wave		Burrs		· '	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
	Cuffs			<u> </u>	Contamination	L	4	tions Incomplete/Unclear	<u> </u>	Part Moved		Wrong Stock Pulled
	Crushing				Countersink		1	gned/off center	<u> </u>	Positioned V		-
	Heat Trea				Cut Too Short	L	Mislabe			Power Loss/	Surge	Other
	Inspectio	•	Tube		Drawing	L	Misrea					
	Marks/Cl	natter			Drill Holes		Off-set					
	Turning Sequence		Finish		ł	Calibration						
	Wave/Twist in Tube			Fit/Function	Out of Sequence							

Work Order ID 110351 December-17-13 9:24:00 AM				*11(-		·	Page 3			
Item ID: Revision ID: Item Name:	D3651-3 Base			Accept	*N900	040	100)*	Setup Sta	**1	JS1* JS2*
Start Date: Required Date Reference:	12/17/13 e: 12/17/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:	D:					
Approvals: Process Plan:		Date:	Tooling: SPC (Y/N):		nte:]	Run Sta Sta	`` ```	JR1* JR2*	
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Numb	-

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

160

160

Quality Control

Number Stamp

14/12/2 **

Number Stamp

DQA:			Date:												
						WORK ORDER NON	-CC	ONFO	RMANCE / UP					AEROSPACE	
QA Closed:			Date:								Vork Order ι	ipdate only			
Work Orde	ar.					DISPOSITION				AGAINST D	EPARTMEN	T/PROCESS			
VVOIK OTUC	٠					Rework	1		Skid-tube	Crosstube		Water Jet		Engineering	
Part N	lo.					Scrap	1		Machining	Small Fab	Pr	od. Eng. Coor.	-	Quality	
	•	•				Use-as-is	1		moforming	Finishing	Rec/Store/Packaging Other				
NCR N	۰۰۸			·····		Suspected Unapproved				Supplier					
Root					Desc	scription of work order update Initial Action		Sign &							
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	otion	Date	Verificatio	n	QC Inspector	
Design															
Doc/Data															
Equip/Tooling											ı.				
Handling/Pre						•									
Material															
Operator															
Offset/Setup															
Process															
Supplier															
Training															
Transport		·													
Unapproved							<u> </u>								
							FA	ULT CA	TEGORY						
Landi	ng G				_	General	Γ] <i></i> .	.	r	Outside Dir			Pressure/Forced	
		Bending			┝	Bend	\vdash	1	Program	-	_	r tolerance	\vdash	Set-up	
		Centre No	ot Concer	ntric	\vdash	BOM/Route	\vdash	Grain		<u>}-</u> -	Part Incorr		\vdash	Temperature/Cure	
		Cracks	. 1. /p: 1 .	ha	<u> </u>	Broken/Damage/Defect	\vdash	Hardwa		uslified -	Part Lost/N			Weld	
	Ĭ	Crimp/Ki	nk/Ripple	/wave	-	Burrs	-	4 '	ion Incomplete/Unq	· -	Part Move	-	\vdash	Wrong Stock Pulled	
	-	Cuffs			-	Contamination	-	4	tions Incomplete/Un	lciear	Positioned		L	Wrong Stock Fulled	
	\vdash	Crushing			-	Countersink	\vdash	Mislabe	gned/off center	-	Power Loss	-		Other	
	-	Heat Trea		Tuka	-	Cut Too Short	-	Misrea		Ł	Trower ross	Juige		Other	
	-	Inspectio	•	rupe	-	Drawing Drill Holes	\vdash	Off-set							
	\vdash	Marks/Ch			\vdash	4	\vdash								
	Turning Sequence		Finish Fit/Function	Out of Campration Out of Sequence											
	Wave/Twist in Tube			ן דווין רעווכנוטוו		Jour of .	Jequence								

Picklist Print

December-17-13 9:23:59 AM

Work Order ID:

110351

Parent Item:

D3651-3

Parent Item Name:

Base

Start Date: 12/17/13

Required Date: 12/17/13

Page 1

Start Qty: 1.00

193135

Required Qty: 1.00

Comments:

IPP Rev:A New Issue 07-09-27 DD verified by: EC

IPP Rev:B ECN 1113P 08-01-22 DD

DD verified by: EC

122753

123135

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S26GA 304/316 0.018 SHEET		Purchased	No			100	sf	278.7400	0.474	1		2	43 14-09
				Location		Loc Qty	<u>L</u>	oc Code					
				MAT020		278.74							
				117	798	69.28			***********				

89.46

120

	TOART							
WORK ORDER NON-CONFORMANCE / UPDATE	AEROSPACE							
QA Closed: Date: Work Order update only								
Work Order: DISPOSITION AGAINST DEPARTMENT/PROCESS								
Rework Skid-tube Crosstube Water Je	et Engineering							
Part No. Scrap Machining Small Fab Prod. Eng. Coo	F-1 - F-1							
Use-as-is Thermoforming Finishing Rec/Store/Packagin								
NCR No Suspected Unapproved Large Fab Composite Supplie	er 🗌							
Root Description of work order update Initial Action Sign &								
Cause Date Step Qty or non-conformance Chief Eng Description Date Verificat	ion QC Inspector							
Design Control								
Doc/Data Doc/Data								
Equip/Tooling								
Handling/Pre								
Material	}							
Operator Operator								
Offset/Setup								
Process Process								
Supplier								
Training								
Transport								
Unapproved								
FAULT CATEGORY								
Landing Gear General	□p /p							
Bending Bend Folio/Program Outside Dimensions	Pressure/Forced							
Centre Not Concentric BOM/Route Grain Over/Under tolerance	Set-up							
Cracks Broken/Damage/Defect Hardware Part Incorrect	Temperature/Cure Weld							
Crimp/Kink/Ripple/Wave Burrs Inspection Incomplete/Unqualified Part Lost/Missing Cuffs Contamination Instructions Incomplete/Unclear Part Moved	Wrong Stock Pulled							
	wrong stock runed							
	Other							
Heat Treat Cut Too Short Mislabeled Power Loss/Surge Inspection Strip in Tube Drawing Misread	Journel							
Marks/Chatter Drill Holes Off-set								
Turning Sequence Finish Out of Calibration	W							
Wave/Twist in Tube Fit/Function Out of Sequence								

DART AEROSPACE LTD	Work Order:	1103.87
Description: Base	Part Number:	D3651-3
Inspection Dwg: D3651 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.100	-		U	Jhmo)
Ø0.213	+0.005/-0.001	0.215	-		J	•
11.07	+/-0.030	11.07"			V	Thurs.
7.92	+/-0.030	7.92"	_		J	
6.55	+/-0.030	6.55	_		V	
2.73	+/-0.030	2.73"	_		V	
2.54	+/-0.030	2-54"	_		J	
0.81	+/-0.030	0.81	_		V	
3.00	+/-0.030	3.00	_		J	
1.43	+/-0.030	1.43"	_		V	
3.61	+/-0.030	3.61"	_		J	
1.96	+/-0.030	1.96"			U	
5.25	+/-0.030	5.25		-	U	
0.018	+/-0.010	0.018	-		U	
	DAS		DAS			

| Measured by: | 9-89 | Audited by: | 9-89 | Prototype Approval: N/A |
| Date: 14/08/18 | Date: N/A |

Rev	Date	Change	Revised by	Approved				
Α	08.04.17	New Issue	KJ/DD 1.4					
В	08.10.07	0.018 dimension added	KJ/DD 🗸	<i>S</i>				

D -INSTALL CR3523-4-02 OR NAS9307M-4-02 RIVET (58 PLACES) 110351 MCJ 13-12-18 -D3651-13 OUTSIDE DOUBLER -D3651-11 GASKET D3651-9 INSIDE DOUBLER PART LIST QTY -041 PART NUMBER DESCRIPTION D3651-041 AFT BASE ASSEMBLY D3651-043 FLANGE WELDMENT -D3651-043 FLANGE WELDMENT 1 D3651-1 1 D3651-9 GASKET INSIDE DOUBLER

D3651-041 AFT BASE ASSEMBLY

	В	S	HEETS 4	5, 6 5, 6 5,514	/AS 8.5 8 & 9: (WAS 5.	0; 0.88 WAS 0.98; REMOVED ANGLE GENERAL DIMENSIONAL UPDATE 504	KF.	08.01.07	
	A	NE	w Issu				RF	07.11.07	1
D3651-041 NOTES:	REV	/.			-	DESCRIPTION	BY	DATE	1
1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT	DESI	IGN		R	F	DART AEROSPA	CEI	TD	١,
2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357	DRA	WN		R	F	HAWKESBURY, ONTARI			1 ~
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED	CHE	CKED		\overline{C}	F	DRAWING NO.		REV. B	ı
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX	MFG	. APP	R.	Δ	δ^{-}	D3651		SHEET 1 OF 9	1
6) IDENTIFICATION: NONE 7) WEIGHT: 1.6 lbs	APP	ROVE	D	M	7	TITLE		SCALE	1
/) WEIGHT. I.O IDS	DE A	PPR.				AFT BASE ASSEMBL	Y	1:4	1
	DATE	Ė (18 O1	Λ7	1	COPYRIGHT © 2007 BY DART A THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED			1

∠D3651-1 GASKET ②

В

D3651-11

D3651-13 CR3523-4-02 or NAS9307M-4-02

GASKET

RIVET

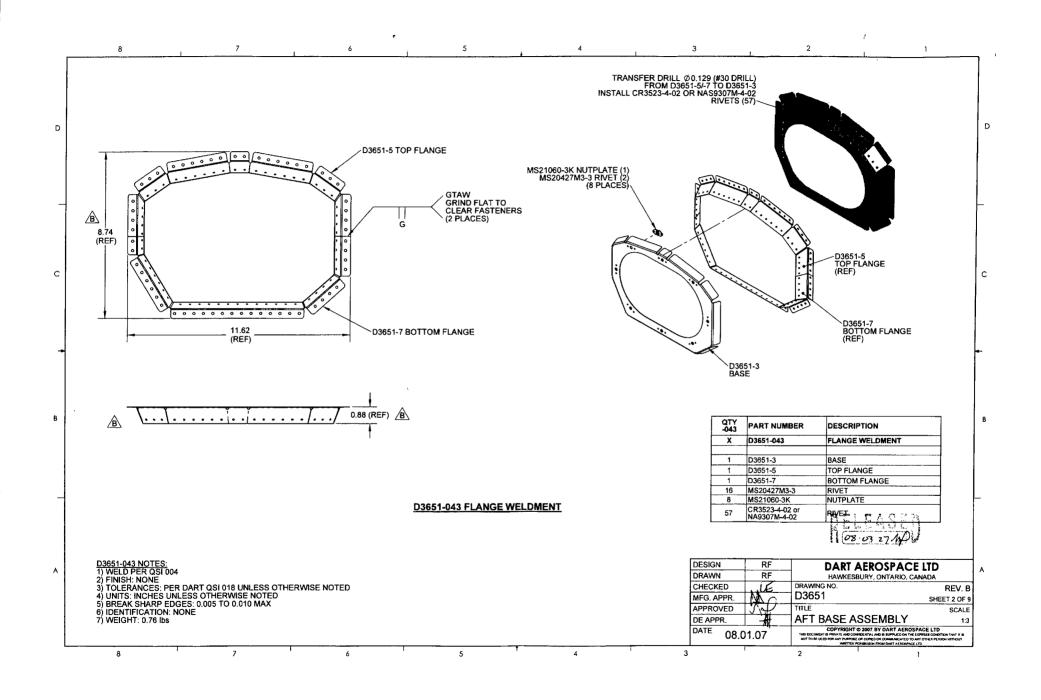
OUTSIDE DOUBLER

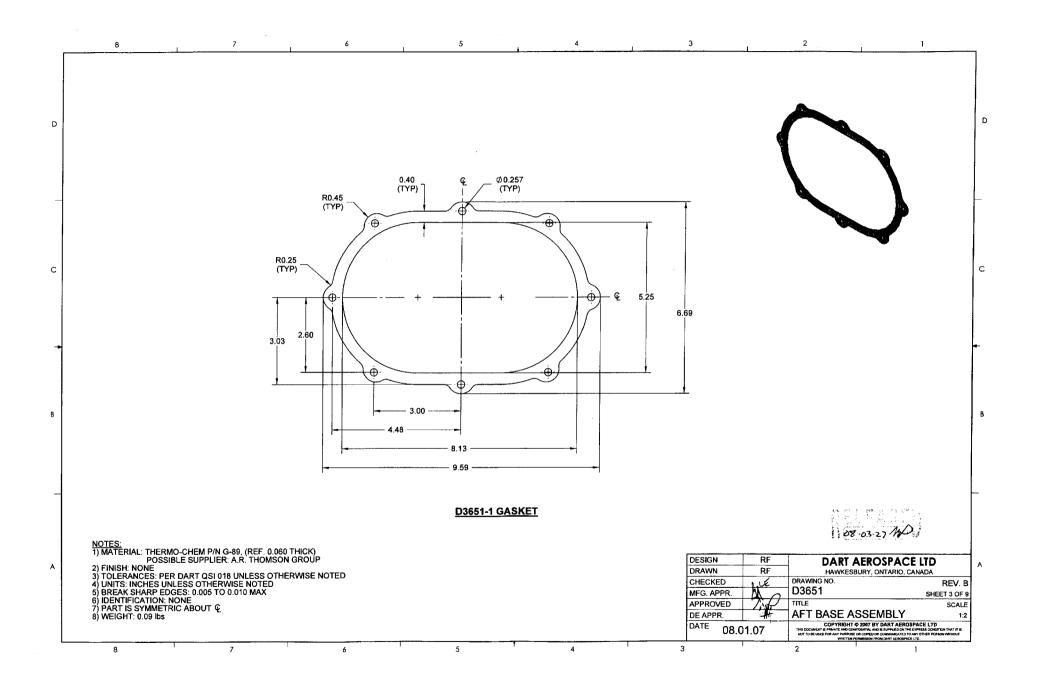
SHEET 1: GENERAL UPDATE

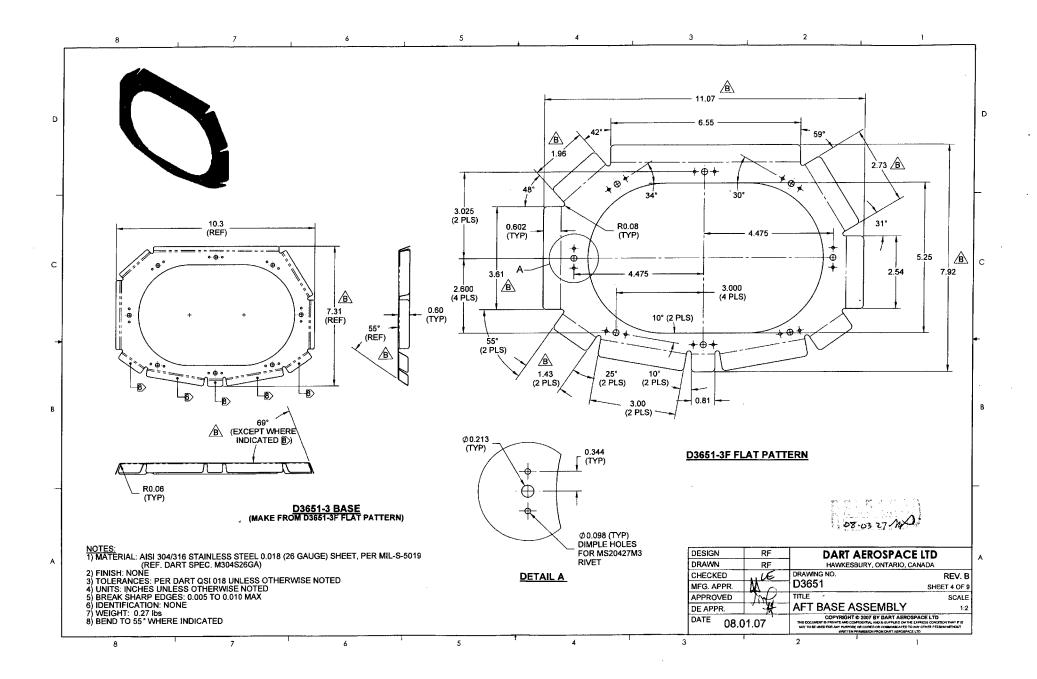
D

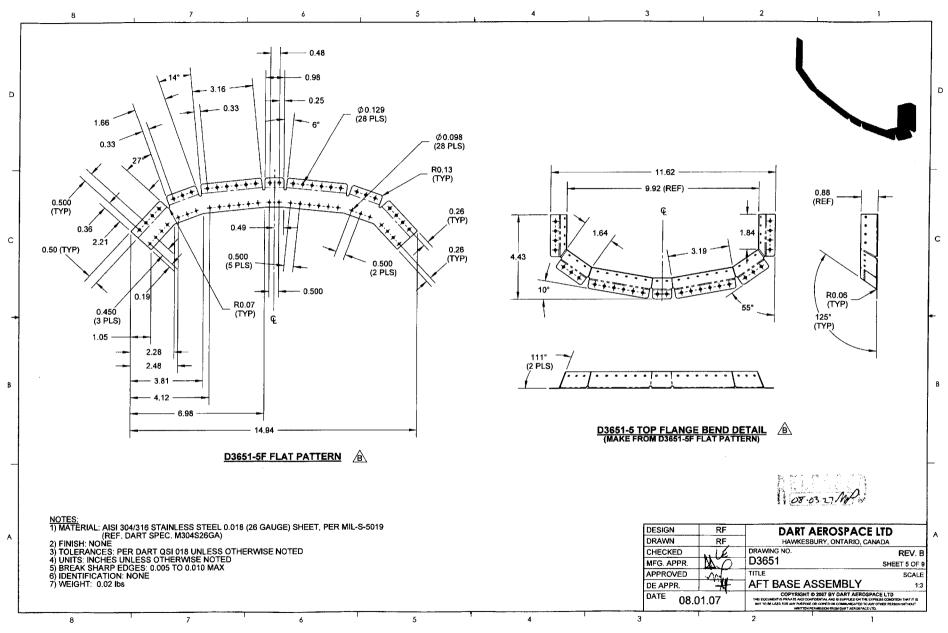
С

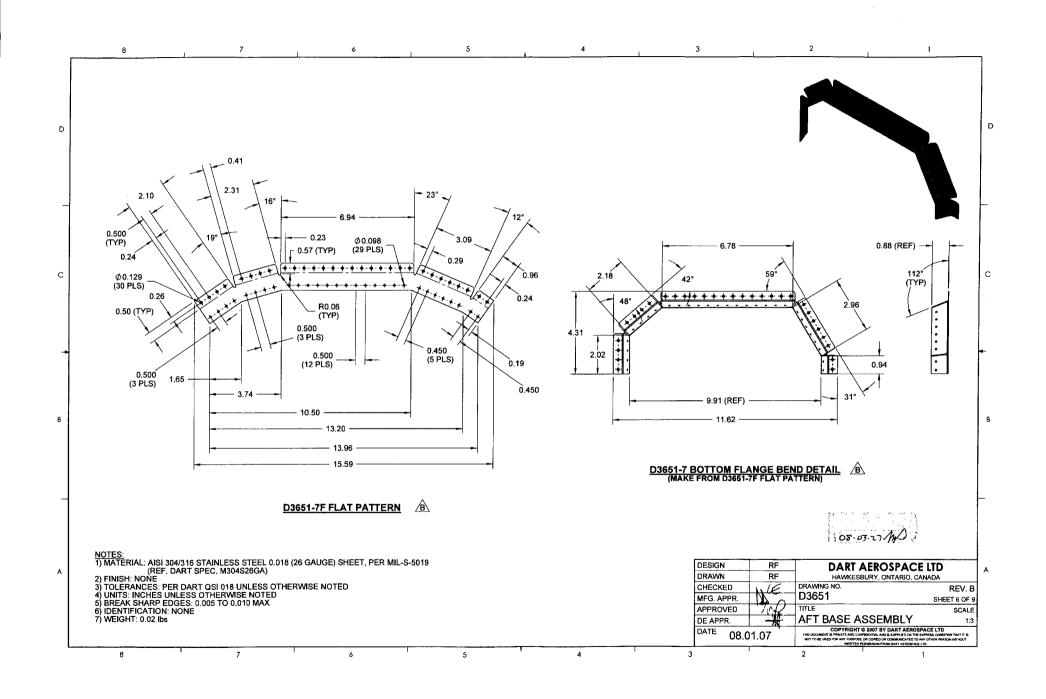
В

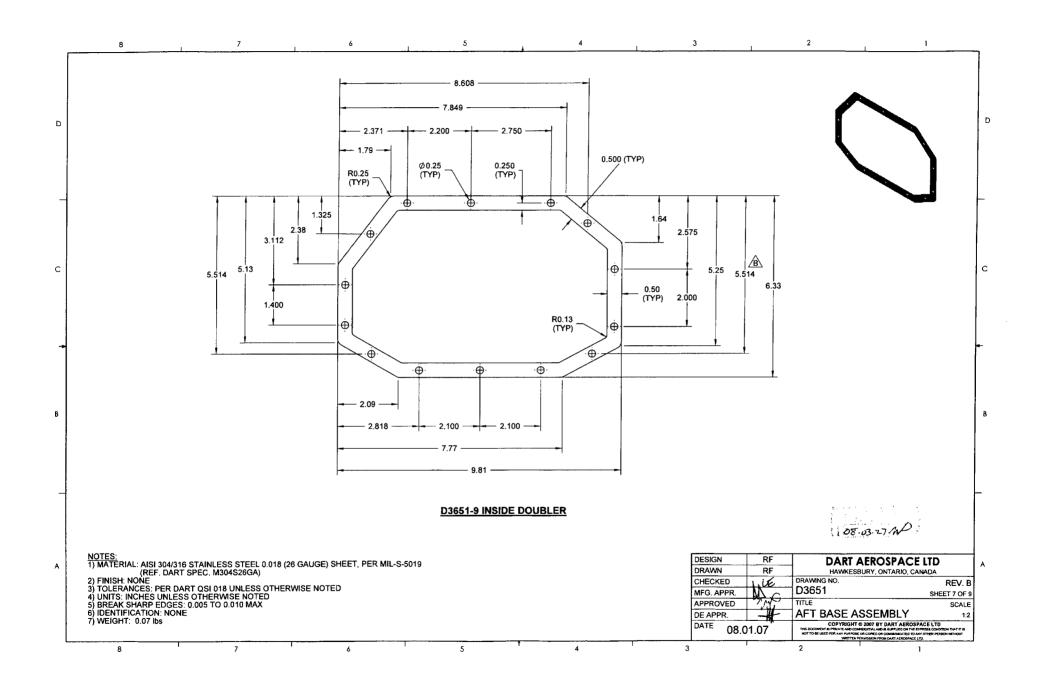


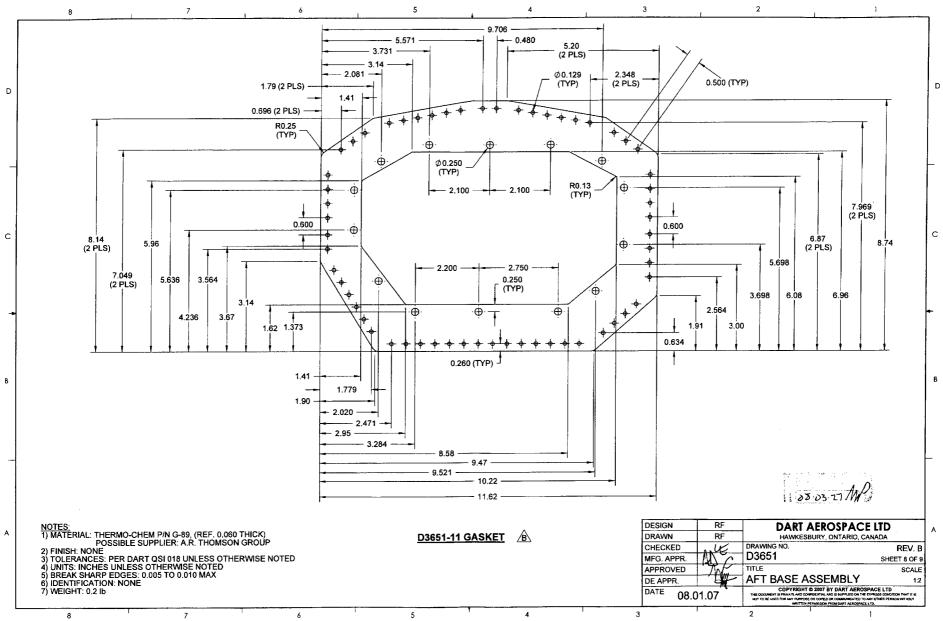


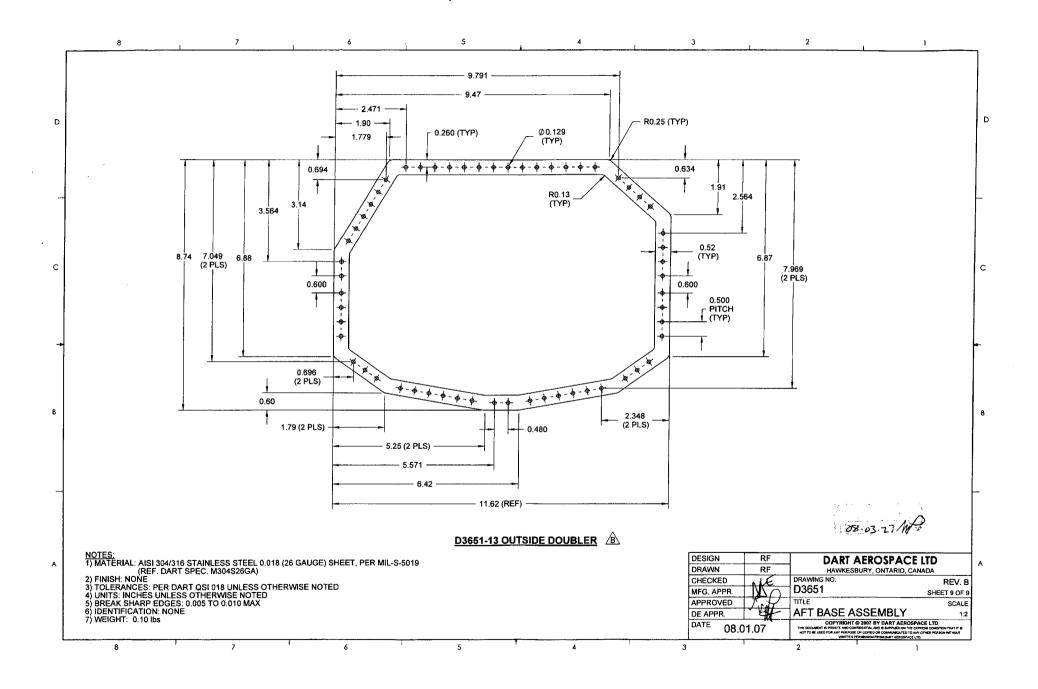












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